

Work Order ID 55497

January 19, 2010 1:41:37 PM



Page 1

Item ID: D350-636-014

Accept



Setup Start



Revision ID:

Stop



Item Name: Skiddtube RH

Start Date: 1/19/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *PL*Date: *10-1-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

0.00

100



DC

DOCUMENT CONTROL

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-014 CHG 005

*5/10/2/01**JG for MF 10/01/30***B 55497**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: SPC (Y/N):

Date:

Sequence ID/
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DescriptionSet Up/
Run HoursDraw
NumberDraw
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CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 7 (D2750-4 details).Drill using drill Jig DT8150 & DT8864 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolt using DT8983. Open to 0.500".

5- locate DT8929 off of blade fitting holes and drill pilot holes for blade fitting.

6-Open up holes for section BE-BE to 0.375 (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail A-B to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297"

8-Open up holes of Detail A-A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R. Aluminum Rod

M112860

BB 10/01/21

10-Grind welds flush as per Dwg D2750

H 10/1/21

H 10/1/21

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11- scribe batch #.

u 10/1/21

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

⇒ 8106121

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⇒ 8106121

(40) /

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

1 u 10/1/21

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

10-1-21

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan:

Date:

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Date:

QC:

Date:

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Run Start

Stop

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Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: M112335

exp. date: 10/1/30

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 11)

A/R Aluminum Rod

batch: M112860

BE 10/01/25

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

M 10-1-21

M 10/1/25

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

⇒ 8.06.125



Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

⇒ 8.06.125



f

Quality Control

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

PR 10-01-26



φ

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M113170

=> JH

10-01-26

(X)

0

Memo

0.00

START TIME: 1:10pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 1:40pm

210



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Inspect for foreign object per QSI 024

=> M-L 10/01/27

(IX)

220



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

1-Install inserts as per dwg D2750

2-assemble o'ring as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: M101223

=> M-L 10/01/27 (IX)

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Assemble tube hardware as per dwg D2750 sikaflex batch: M112391

2-Inspect For Foreign Objects

3-Spray inside of tube with "LPS-3" batch: N/A

4-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: M112391

EXP DATE: 10/08

5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M101223

6-Coat all exposed fasteners with "LPS Procyon" batch: M104251

=> M-h 10/01/27

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 8106627

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10-1-29

SP

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

28.062101

70

270



Packaging

Packaging

Packaging

0.00

Memo

0.00

Package as per PPP D350-636-014

Rev H

10-2-8

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

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Approvals: Process Plan: Date:

Tooling:

Date:

QC: Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
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Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/09 *[Signature]**MK*
10-2.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

January 19, 2010 1:41:42 PM

Page 1

19

Work Order ID: 55497



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev: H 02.09.25 Rearranged procedure steps KJ
 IPP Rev: I 05.12.08 Rearranged procedure steps EC
 IPP Rev: J 06.03.30 Per rev. D EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

13.0000

1.0000



Extrusion Bent

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

5

50675

5

BB39007

Main Warehouse

ST

8

43495

1

47133

1

52346

6

1

M 10/1/21

D2739

Manufactured No

160

Each

8.0000

1.0000



350 I Beam

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8

47124

1

53900

3

55034

4

1

M 10/1/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP Rev: J 06.03.30 Per rev. D ECE
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 243.0000 8.0000



Crossbolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 52

50281 50

51913 2

Main Warehouse

ST 191

44891 2

45555 17

48275 1

52310 171

D2744 Manufactured No 160 Each 57.0000 1.0000



Cap

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 57

44892 1

47488 23

51922 33

BE 10/01/26

14 10/11/21

January 19, 2010 1:41:42 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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 IPP Rev:I 05.12.08 Rearranged procedure steps [EC]
 IPP Rev:J 06.03.30 Per rev. D [EC]
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No 160 Each 60.0000 4.0000



Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	60	
45338	2	
47657	2	
48277	16	
51932	40	

4 BE 10/01/26

D3490-5 Manufactured No 160 Each 63.0000 4.0000



Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	63	
43015	22	
46490	41	

4 BE 10/01/26

W/O:		WORK ORDER CHANGES					
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 IPP Rev: I 05.12.08 Rearranged procedure steps: EC
 IPP Rev: J 06.03.30 Per rev. D EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

6,686.000 38.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6686

107441

16

110768

6670

AN3C5A

Purchased

No

230

Each

909.0000 34.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

909

111424

8

111707

69

112314

1

113121

231

113149

300

113644

300

m-l
~~38x~~ 10/01/27

~~34x~~ *m-l* 10/01/27

W/O:		WORK ORDER CHANGES					
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Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps:KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps:EC
 IPP Rev:J 06.03.30 Per rev. D IEC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 804.0000 4.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

804

111982

804

AN6C44A Purchased No 230 Each 148.0000 4.0000



BOLT

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST

146

110105

4

110155

14

110665

1

111605

50

111649

50

112720

9

113121

18

4x m-l 10/01/27

4x m-l 10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55497



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev: H 02.09.25 Rearranged procedure steps [KJ]
 IPP Rev: L 05.12.08 Rearranged procedure steps [EC]
 IPP Rev: J 06.03.30 Per rev. D [EC]
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN8C35A Purchased No 230 Each 137.0000 1.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	137	
102180	1	
106896	1	
110105	48	
110847	87	

AN960C10L Purchased No 230 Each 388.0000 38.0000



washer

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG	100	
103585	100	

Main Warehouse

ST	288	
112116	128	
112612	160	

NA S1149C0332R

M113288

38X

m-l

10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55497



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased

No

230

Each

240.0000 1.0000



WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	240	
104093	2	
107520	4	
110139	29	
110584	100	
111424 ✓	105	

10/01/27
 M.L
 1X

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55497



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev: H 02.09.25 Rearranged procedure steps KJ
 IPP Rev: I 05.12.08 Rearranged procedure steps EC
 IPP Rev: J 06.03.30 Per rev. D EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No 230 Each 346.0000 8.0000



Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 36

43754 2

44893 33

45556 1

Main Warehouse

ST023 23

34817 2

36230 8

37303 1

39587 2

40726 2

41114 2

42778 6

Main Warehouse

ST46 287

51537 70

51910 36

52311 181

8x m-l
10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55497



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev: H 02.09.25 Rearranged procedure steps KJ
 IPP Rev: I 05.12.08 Rearranged procedure steps EC
 IPP Rev: J 06.03.30 Per rev. D EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3488-042 Manufactured No 230 Each 16.0000 1.0000



Blade Fitting Assembly, RH

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

16

29043

1

52666 ✓

15

D3492-1 Manufactured No 230 Each 78.0000 8.0000



Plug

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

78

46101

1

46692

1

47472

1

47658 ✓

39

48274

36

replaces D3492-041

10/01/27
 1X M-L

8X M-L
 10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55497

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps[KJ]
 IPP Rev:I 05.12.08 Rearranged procedure steps[EC]
 IPP Rev:J 06.03.30 Per rev. D [EC]
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 1/19/10

Required Date: 1/25/10

Start Qty: 1.00

Required Qty: 1.00

D3492-5 Manufactured No 230 Each 55.0000 8.0000



Plug

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	55	
46993	1	
47659 ✓	54	

replaces D3492-045

D3535-25 Manufactured No 230 Each 15.0000 1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	7	
51927 ✓	7	
Main Warehouse		
ST	8	
52589	8	

8X M-L 10/01/27

1X M-L 10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55497



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev: H 02.09.25 Rearranged procedure steps KJ
 IPP Rev: I 05.12.08 Rearranged procedure steps EC
 IPP Rev: J 06.03.30 Per rev. D EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

40.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP10

35

51607

9

54479

26

Main Warehouse

ST

5

45569

1

47011

2

47526

2

D3537-1

Manufactured No

230

Each

141.0000

3.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

2

48288

2

Main Warehouse

FP17

139

51678

34

51679

105

1x m-l
10/01/27

3x m-l
10/01/27

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55497



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev:H. 02.09.25 Rearranged procedure steps:KJ
 IPP Rev:I. 05.12.08 Rearranged procedure steps:EC
 IPP Rev:J. 06.03.30 Per rev. D EC
 IPP Rev:L. 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D3631-I Manufactured No 230 Each 442.0000 8.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	442	
52693	142	
54388	300	

10/01/27
 8X m-l

D3672-I Manufactured No 230 Each 1,744.0000 4.0000



Phenolic Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1244	
39275	19	
42329	5	
47628	220	
52505	1000	
Main Warehouse		
ST117	500	
51674	500	

4X m-l
 10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55497



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev: H 02.09.25 Rearranged procedure steps [KJ]
IPP Rev: I 05.12.08 Rearranged procedure steps [EC]
IPP Rev: J 06.03.30 Per rev. D [EC]
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No 230 Each 11.0000 1.0000



Wearplate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

7

51610

7

Main Warehouse

ST

4

51909

4

D3793-1 Manufactured No 230 Each 19.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

19

40551

1

51597

16

51906

2

IX m-l
10/01/27

IX m-l
10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55497



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D3793-3 Manufactured No 230 Each 16.0000 1.0000



Wearshoe

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	16	
51592	12	
51903	4	

10/01/27
 1X M-L

D3794-1 Manufactured No 230 Each 15.0000 1.0000



Gasket

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	12	
51928	12	
Main Warehouse		
ST	3	
46530	1	
47212	2	

10/01/27
 1X M-L

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55497



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev: H 02.09.25 Rearranged procedure steps: KJ
 IPP Rev: I 05.12.08 Rearranged procedure steps: EC
 IPP Rev: J 06.03.30 Per rev. D EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3794-3 Manufactured No 230 Each 21.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

18

51598

6

51907

12

Main Warehouse

ST

3

46531

2

47440

1

MS21043-6 Purchased No 230 Each 1,000.000 4.0000



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1000

111424

8

112314

992

10/01/27

1x m-l

4x m-l

10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55497



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev: H 02.09.25 Rearranged procedure steps KJ
 IPP Rev: L 05.12.08 Rearranged procedure steps EC
 IPP Rev: J 06.03.30 Per rev. D EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

MS21083C8 Purchased No 230 Each 53.0000 1.0000



NUT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	53
110584	5
111424	2
112493	6
113149	40

NAS1611-005 Purchased No 230 Each 270.0000 1.0000



O-RING

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	270
102022	8
102093	1
105939	1
106099	260

10/01/27
 1x m-l

*
 8x m-l 10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55497



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev: H 02.09.25 Rearranged procedure steps: KJ
 IPP Rev: L 05.12.08 Rearranged procedure steps: EC
 IPP Rev: J 06.03.30 Per rev. D EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

330.0000

1.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

330

110715

44

110915

286

Purchased

No

250

Each

148.0000

2.0000

AN8C21A



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

148

105160

1

107596

1

107924

2

109092

2

110341

2

110342

2

111605

50

112720

38

113558

50

*

10/01/21

8x m-h
P

11/27/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55497



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased

No

250

Each

240.0000

2.0000



WASHER



10-1-29 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

240

104093

2

107520

4

110139

29

110584

100

111424

105

2

D2741

Manufactured

No

250

Each

45.0000

1.0000



Blade, 350 Skidtube



10-1-29 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45

45320

1

47113

4

51931

40

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 19, 2010 1:41:42 PM

Work Order ID: 55497



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev: H 02.09.25 Rearranged procedure steps KJ
 IPP Rev: L 05.12.08 Rearranged procedure steps EC
 IPP Rev: J 06.03.30 Per rev. D EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3493-1 Manufactured No 250 Each 55.0000 2.0000



Washer



10-1-29 sf

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 55

44902 2

47710 53

D3672-13 Purchased No 250 Each 948.0000 2.0000



Phenolic Washer



10-1-29 sf

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 948

54363 948

MS21083C8 Purchased No 250 Each 53.0000 2.0000



NUT



10-1-29 sf

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 53

110584 5

111424 2

112492 6

113149 40

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Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/2-/3-/4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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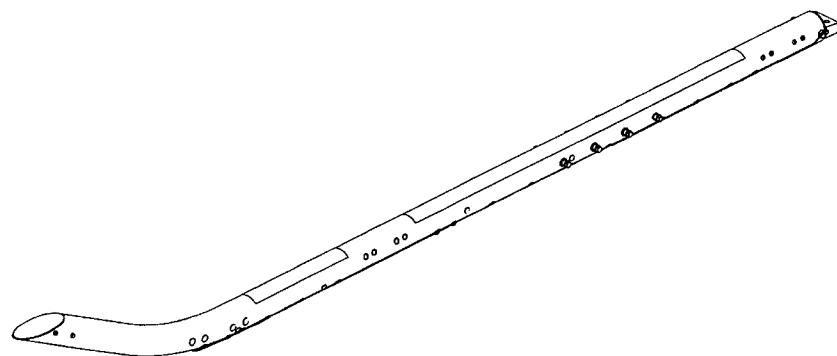
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WORK ORDER

NO. 35497

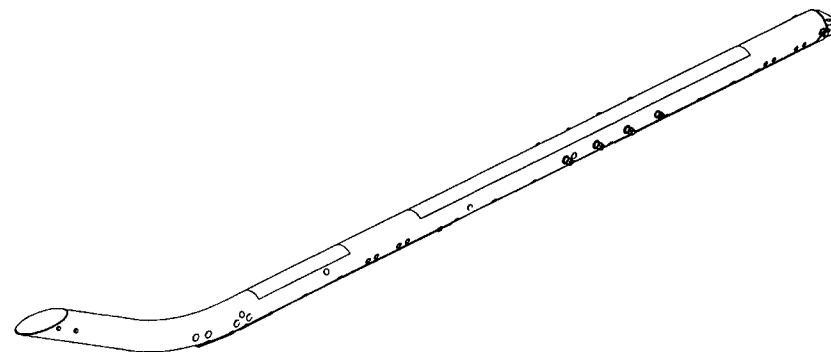
BJ10-1-19

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A8-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS: ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
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CHECKED	<u>PL</u>	DRAWING NO.	REV. F
MFG. APPR.	<u>PL</u>	D2750	SHEET 1 OF 11
APPROVED	<u>PL</u>	TITLE	SCALE
DE APPR.	<u>PL</u>	350 SKIDTUBE ASSEMBLY	NTS
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D2750-041 350 SKIDTUBE ASSEMBLY, LH

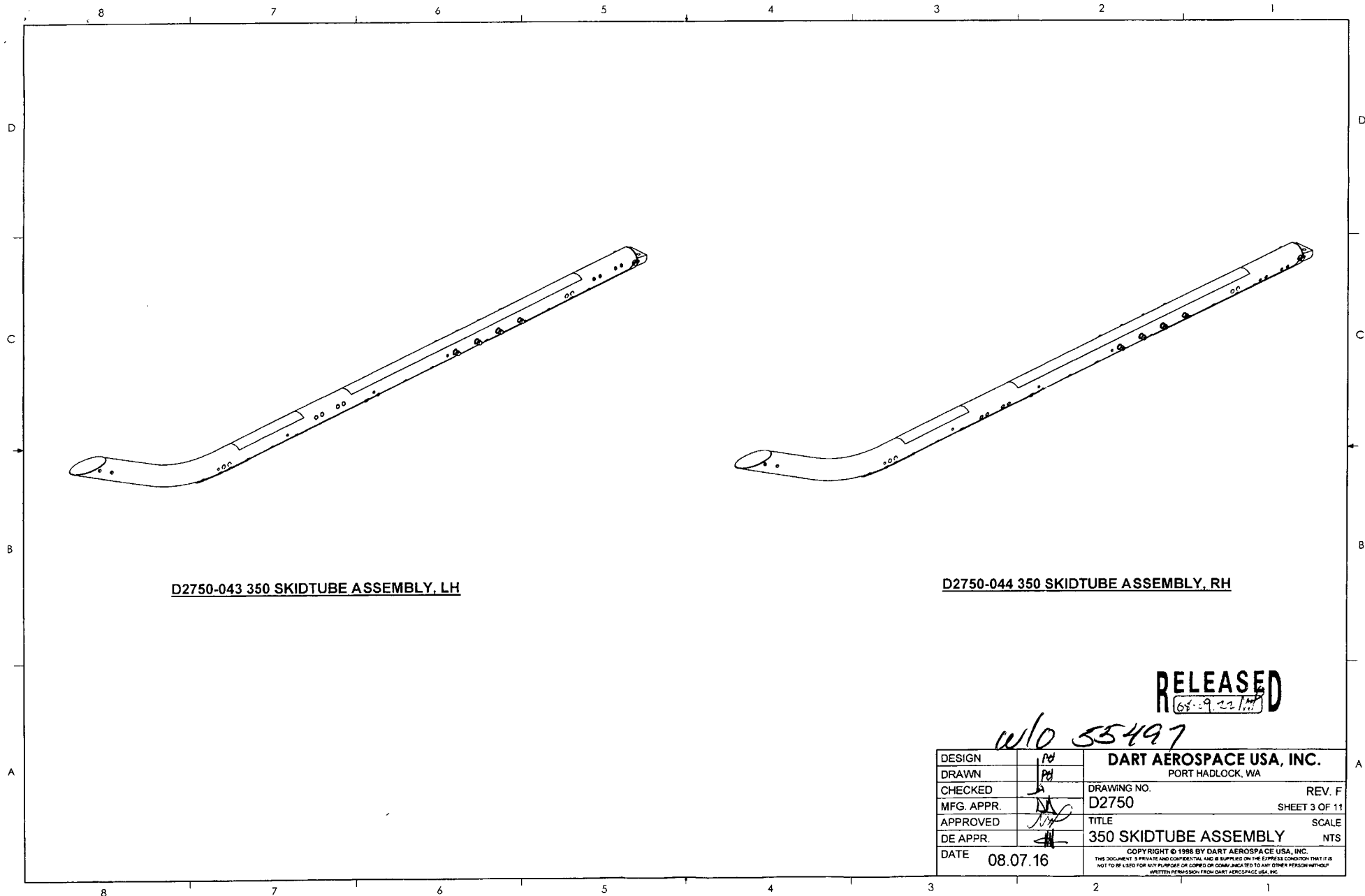


D2750-042 350 SKIDTUBE ASSEMBLY, RH

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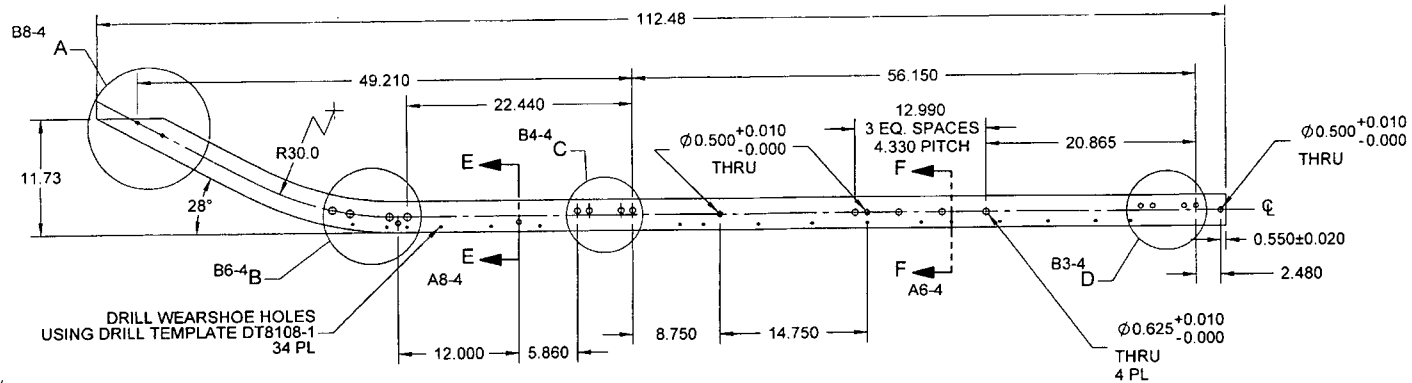
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D2750-044 350 SKIDTUBE ASSEMBLY, RH

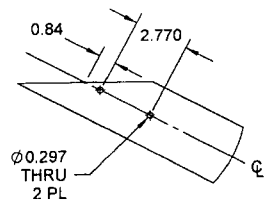
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w/o 55497

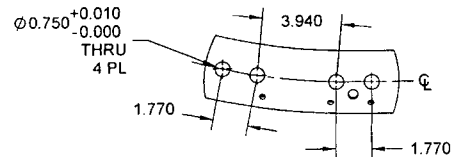
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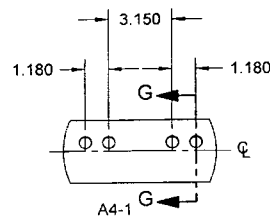
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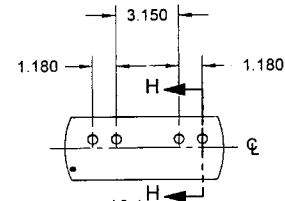
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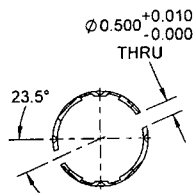
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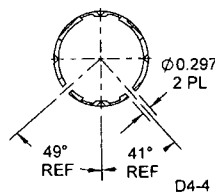
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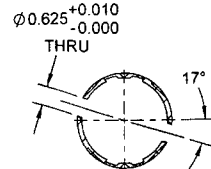
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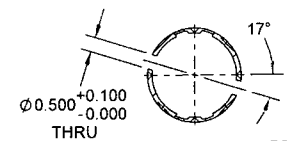
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SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



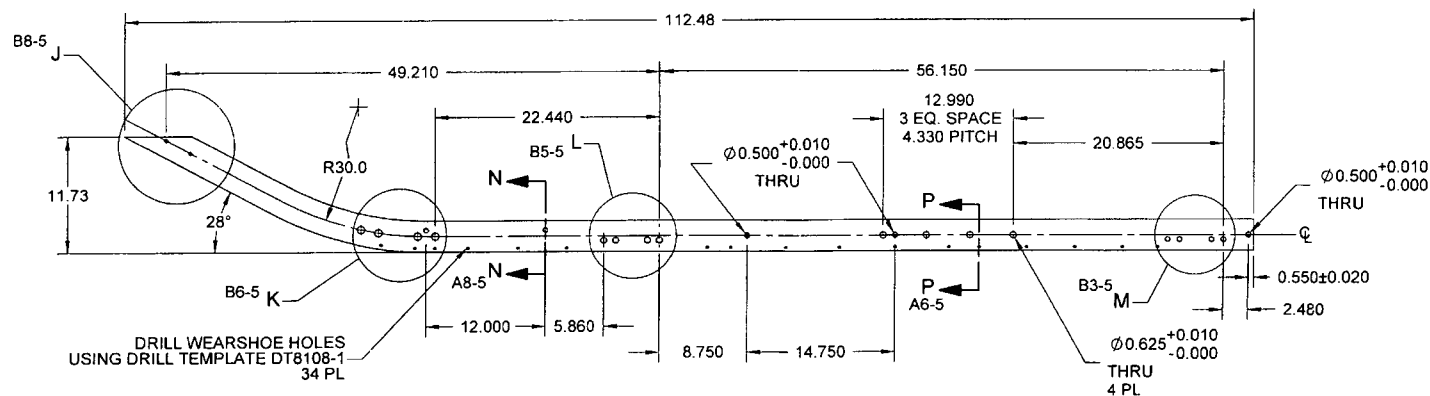
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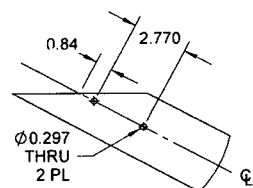
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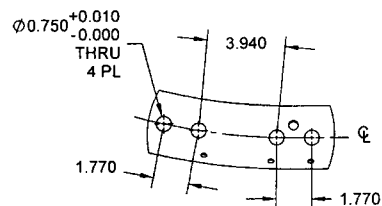
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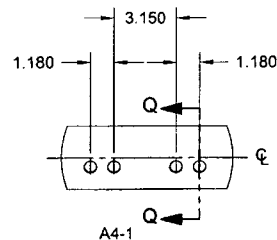
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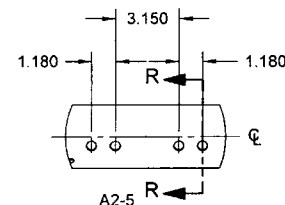
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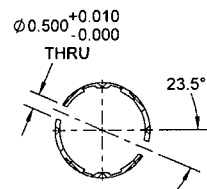
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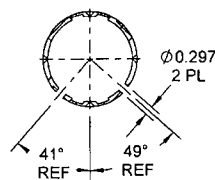
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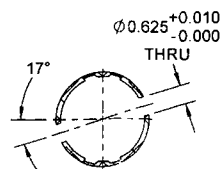
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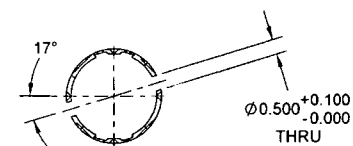
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SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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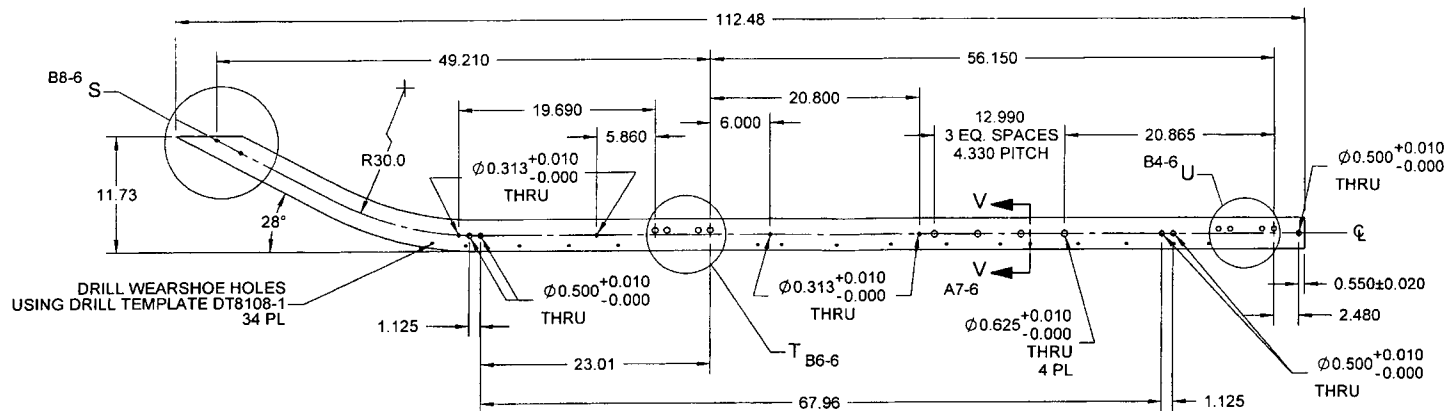
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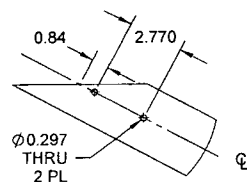
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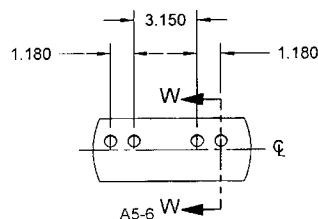
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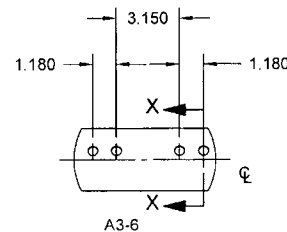
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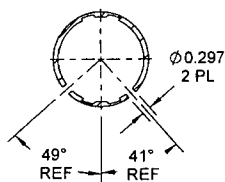
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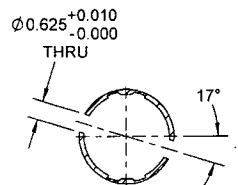
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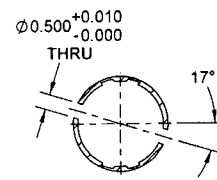
DETAIL U
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SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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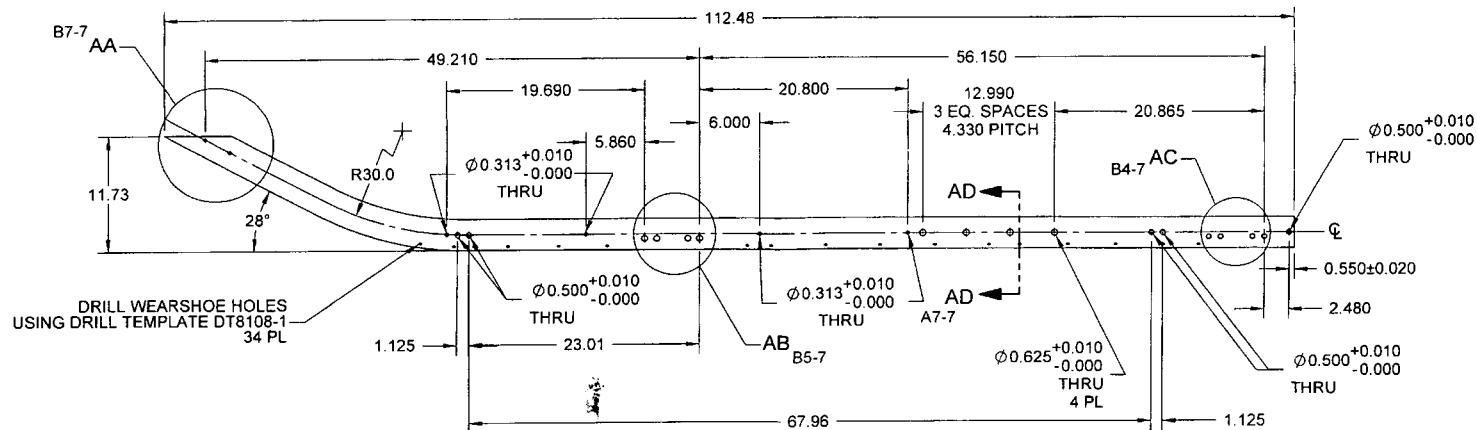
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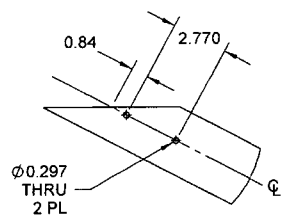
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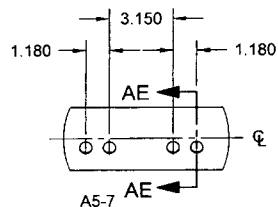
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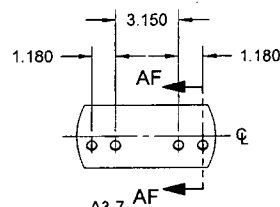
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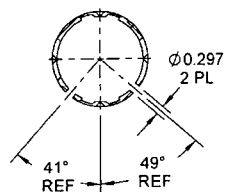
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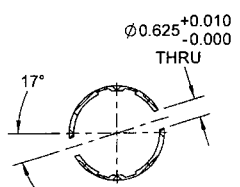
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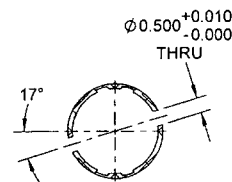
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SECTION AD-AD
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SECTION AE-AE
SCALE 3X, 4 PL

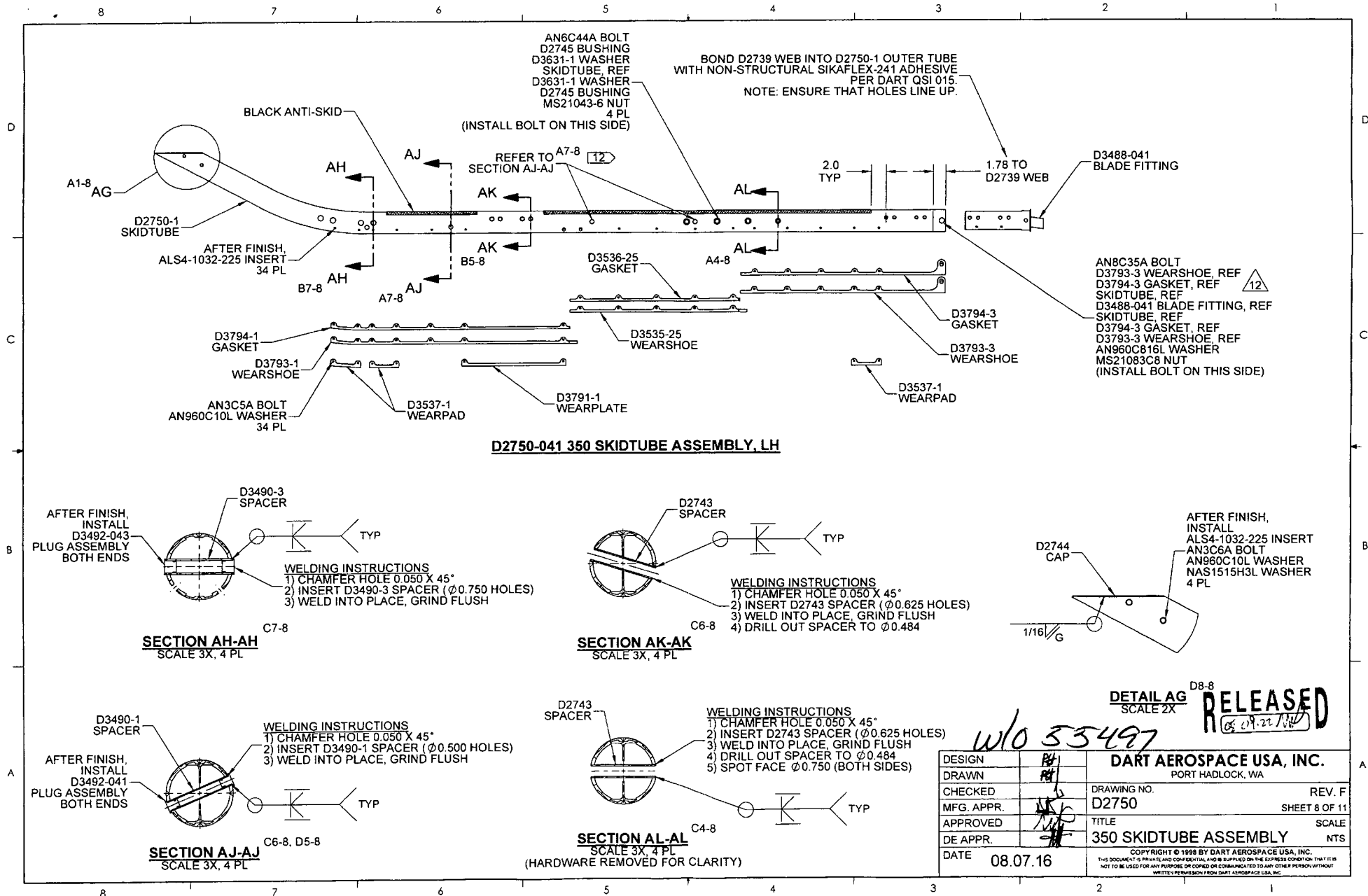


SECTION AF-AF
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D8-8
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DETAIL AG
SCALE 2X

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PORT HADLOCK, WA

REV. F
SHEET 8 OF 11

SCALE
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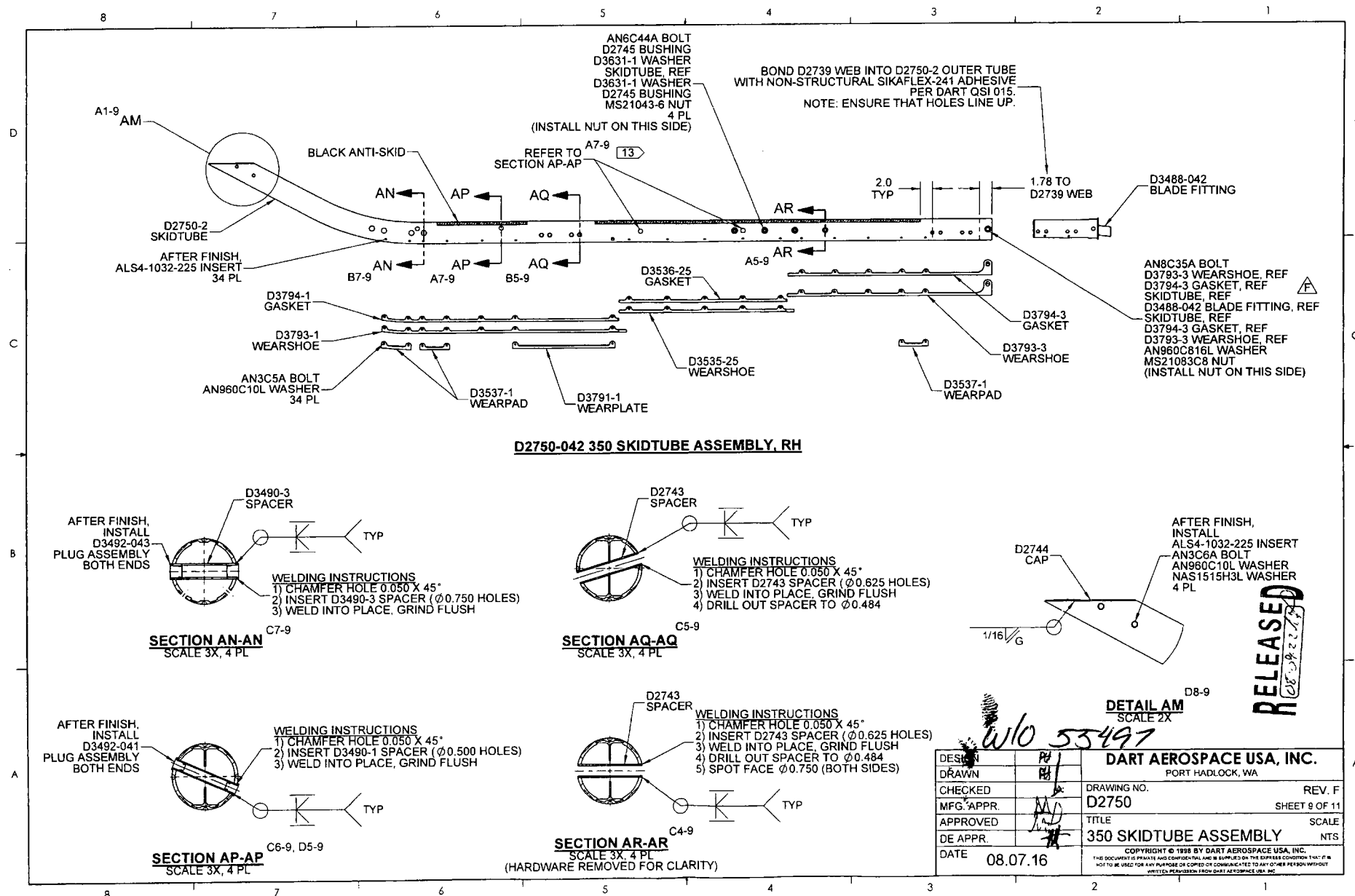
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MFG. APPR.	BY		
APPROVED	BY		
DE APPR.	BY		

D2750

350 SKIDTUBE ASSEMBLY

08.07.16



NO. 222

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 54986
Part number: D350-636 012
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat Dwyer Date of Test Coupon 10.01.11
Welder Barclay Elliott Date of Test Coupon 10-04-11

The above named individual is qualified in accordance with AWS D17.1.2001 to weld